

144603

Thursday, April 28, 2016 10:04:09 AM

N900040100

Setup Start *NS1*

Stop *NS2*

6

Start Date: 5/4/2016 **Start Qty:** 6.00

Cust Item ID:

Required Date: 5/19/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

D4275 A

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blank to 39.750"
Batch: 134776

134553

0.00

0.00

110

110

HAAS 1:

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FB006
DWG REV: A
FOLIO REV: AA

2.67

2.70

2- deburr rough edges

DAS
14
9-89

12/15/08

SL 16-6-15

Work Order ID 144603

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Page 2

Item ID: D4275-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Beam

Start Date: 5/4/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/19/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.06

Quality Control

6 0 166-15

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.12

Quality Control

6 0 DAS
14
9-09
16/06/17

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.90

Hand Finishing

6 0 JF
16/06/29

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Page 3

Item ID: D4275-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Beam
 Start Date: 5/4/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 5/19/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
145 *145* Powdercoat Powder Coating	<i>m 134631.</i> White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo MASK AS PER DWG	0.00 0.30	START: 8:00 CU. T: 320° FINISH: 8:30			6	0	16.00.30.	<i>34</i> 9-89
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.06				<i>6</i>			DAS 38 9-89 JUL 29 2016
180 *180* Packaging Packaging	Identify as per dwg & Stock Location <i>5463</i> Memo	0.00 0.06	DAS 6 9-89			<i>G</i>	<i>R</i>		AUG 02 2016

Work Order ID 144603

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Page 4

Item ID: D4275-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Beam

Start Date: 5/4/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/19/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21 - Final Inspection - Work Order Release

0.00

190DAS
21

AUG 04 2016

QC

Memo

0.60

~~9-09~~

dem

16/08/02

Quality Control

Picklist Print

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Page 1

Work Order ID: 144603

144603

Parent Item: D4275-1

D4275-1

Parent Item Name: Fwd Beam

Start Date: 5/4/2016

Required Date: 5/19/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP
rev:B 10.12.02 AS PER DWG REV.A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased		No		100	f	48.4050	3.3125	20.92105			

M6061T6B1 000X04 000

6061-T6 Bar 1.00 x 4.00

2/16-6-15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT003	48.405	
M126160	0.95	
M129167	35.455	
→ M134553	12	

10. ~~10.50~~

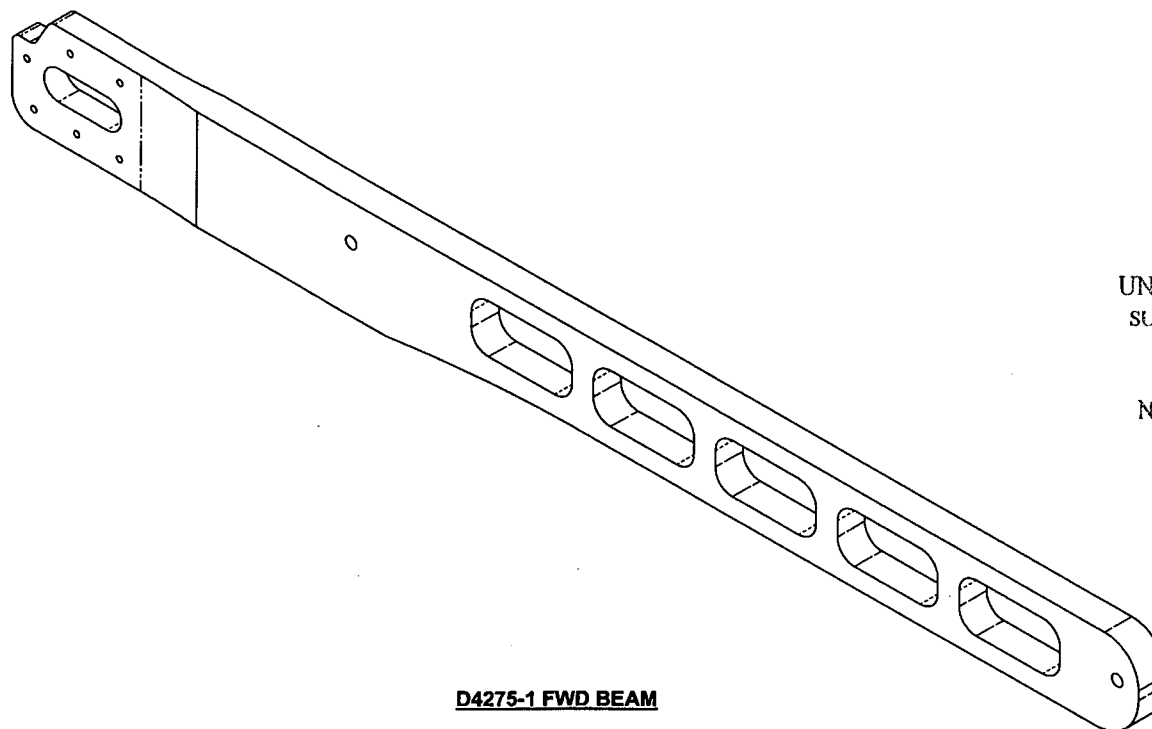
134776 X10

DART AEROSPACE LTD		Work Order:	144603
Description: Fwd Beam		Part Number:	D4275-1
Inspection Dwg: D4275	Rev: A	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	750	✓		VERA	SL-10
26.700	+/-0.010	26.70	✓			
Ø0.381	+0.000/-0.001	380	✓			
8.280	+/-0.010	8.28	✓			
1.44	+/-0.030	1.44	✓			
0.95	+/-0.030	950	✓		HGS	
3.50	+/-0.030	3.500	✓			
13.28	+/-0.030	13.28	✓			
13.50	+/-0.030	13.500	✓			
9.25	+/-0.030	9.250	✓		VERA	CNC-02
5.00	+/-0.030	5.000	✓			
0.75	+/-0.030	749	✓			
2.75	+/-0.030	2.750	✓			
3.00	+/-0.030	3.000	✓			
1.250	+/-0.010	1.250	✓			
4.50	+/-0.030	4.500	✓			
0.734	+/-0.010	736	✓			
0.108	+/-0.010	105	✓			
39.48	+/-0.030	39.48	✓			
0.95	+/-0.030	948	✓			
0.60	+/-0.030	601	✓			
1.750	+/-0.010	1.750	✓			
2.700	+/-0.010	2.700	✓			
1.10	+/-0.030	1.100	✓			
1.25	+/-0.030	1.248	✓			
0.900	+/-0.010	900	✓			
0.75	+/-0.030	750	✓			
0.250	+/-0.010	250	✓			
3.000	+/-0.010	3.000	✓			
1.500	+/-0.010	1.500	✓			
Ø0.191	+0.005/-0.001	193	✓			

099



D4275-1 FWD BEAM

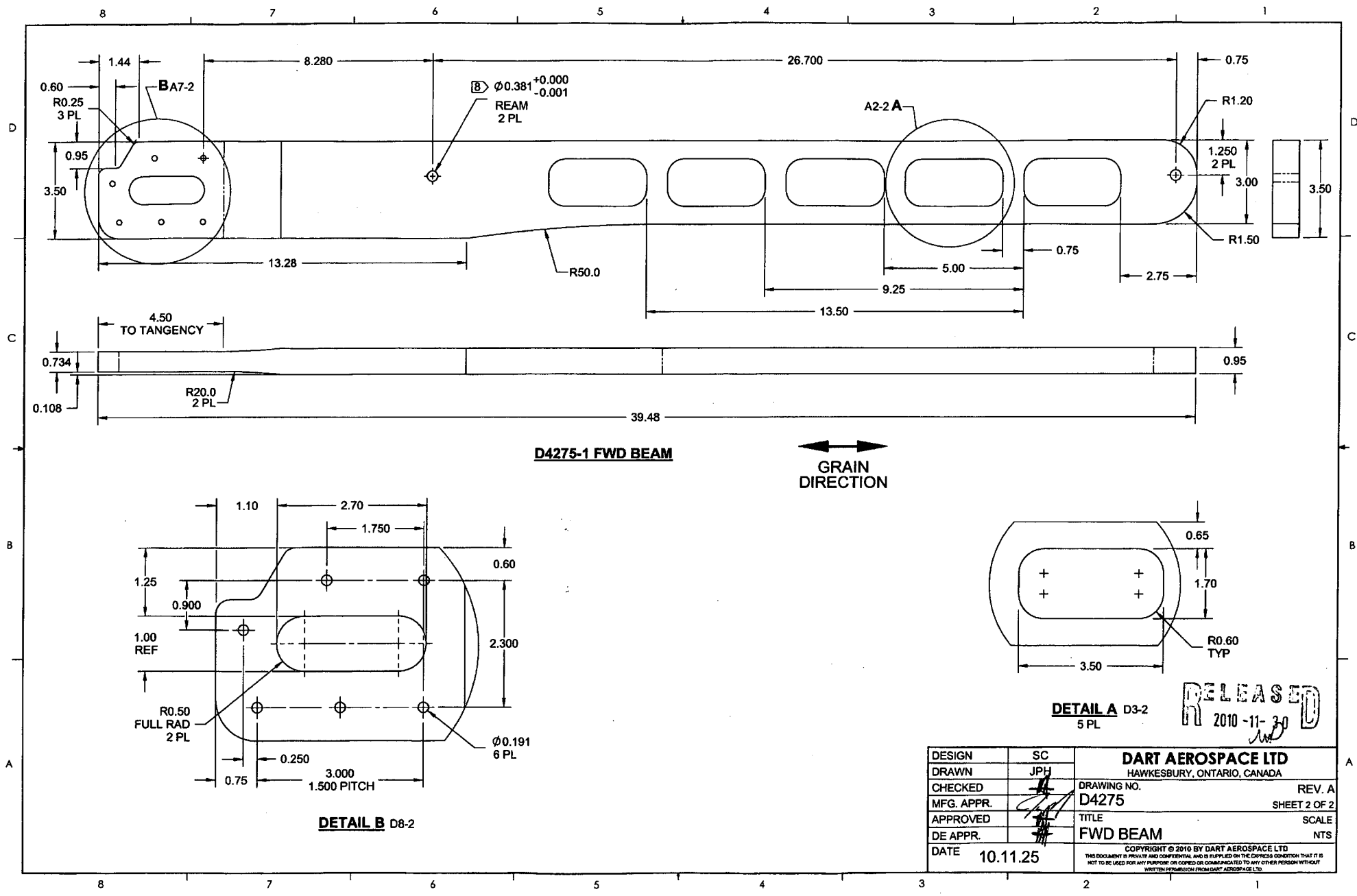
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 144603 ML5
160422

RELEASED
 2010-11-30
JW

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
 PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
 OR ASTM B211 OR ASTM B221
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.29 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT.

A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION		BY DATE
DESIGN	SC	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4275	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD BEAM	NTS
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D4275-1 FWD BEAM

GRAIN
DIRECTION

DETAIL A D3-2
5 PL

RELEASED
2010-11-30

DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4275	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FWD BEAM	NTS
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